

Work Order ID 60373

July 6, 2010 2:58:02 PM

Page 1

Item ID: D3774-1

Accept



Setup Start



Revision ID:

Item Name: Seat Bottom, LH/RH

Stop



Start Date: 7/06/10 Start Qty: 5.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: 2Date: 10/7/6

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3774	Rev B								

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3774-1 ☐ Set up clamping frame as per folio

BB 10/07/15

110

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

BB 10/07/15

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Page 2

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

115



HandThermo

Dry Material

0.00

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F
Time IN: 4:20 PM 10/07/18 BB
Time OUT: 7:00 AM 10/07/19 BB

(XS) BB 10/07/19

120



Thermoform

THERMOFORMING MACHINE

0.00

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3774-1 and Folio ☐ Dwg. Rev.
☒ Folio Rev. C

(XS) BB 10/07/19

130



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

(XS) BB 10/07/19

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 60373

July 6, 2010 2:58:02 PM



Page 3

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Item Name: Seat Bottom, LH/RH

Start Date: 7/06/10 Start Qty: 5.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00							
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo 1) Check dimensions to ensure conformity to drawing tolerances.	0.00 0.00							
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 60373

July 6, 2010 2:58:02 PM



Page 4

Item ID: D3774-1

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Revision ID:

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Item Name: Seat Bottom, LH/RH

Start Date: 7/06/10 Start Qty: 5.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

Identify as per dwg & Stock Location: 270

0.00



Packaging

Memo

0.00

Packaging

Comp/21 (5)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/21 dg
mf
10-7-21

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

July 6, 2010 2:58:02 PM

Page 1

Work Order ID: 60373



Parent Item: D3774-1



Parent Item Name: Seat Bottom, LH/RH

Start Date: 7/06/10

Required Date: 7/20/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV. B Dwg. Update 08.08.19 DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04

Purchased

No

110

sf

687.7068

10.667

53.335



GE PLASTICS LEXAN SHEET



Location

MAT

Loc Qty

687.7068

64

155.783

467.9238

Loc Code

111710

112585

114032

5 BB 10/07/19

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	60373
Description: Seat Bottom		Part Number:	D3774-1
Inspection Dwg: D3774	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 10/07/20

TRIMMING SECTION

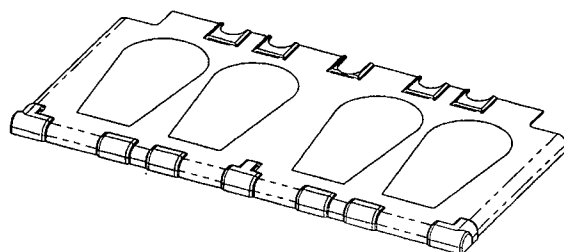
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.309	✓			
33.9	+/-0.100	3.875	✓			
17.4	+/-0.100	14.475	✓			
0.085	Min	.108	✓			
0.100	Min	.105	✓			
0.100	Min	.115	✓			
0.100	Min	.117	✓			
0.100	Min	.111	✓			

Measured by: BB Date: 10/07/20

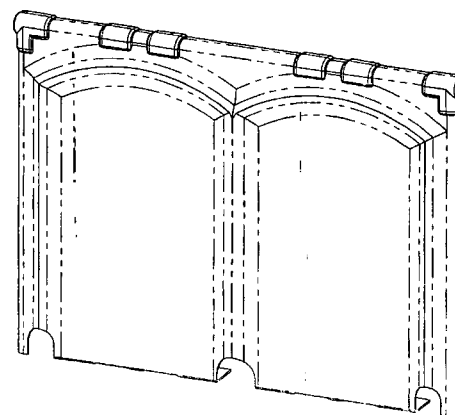
Audited by: Sh Date: 10/07/20

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	<u>Sh</u>



D3774-1 SEAT BOTTOM

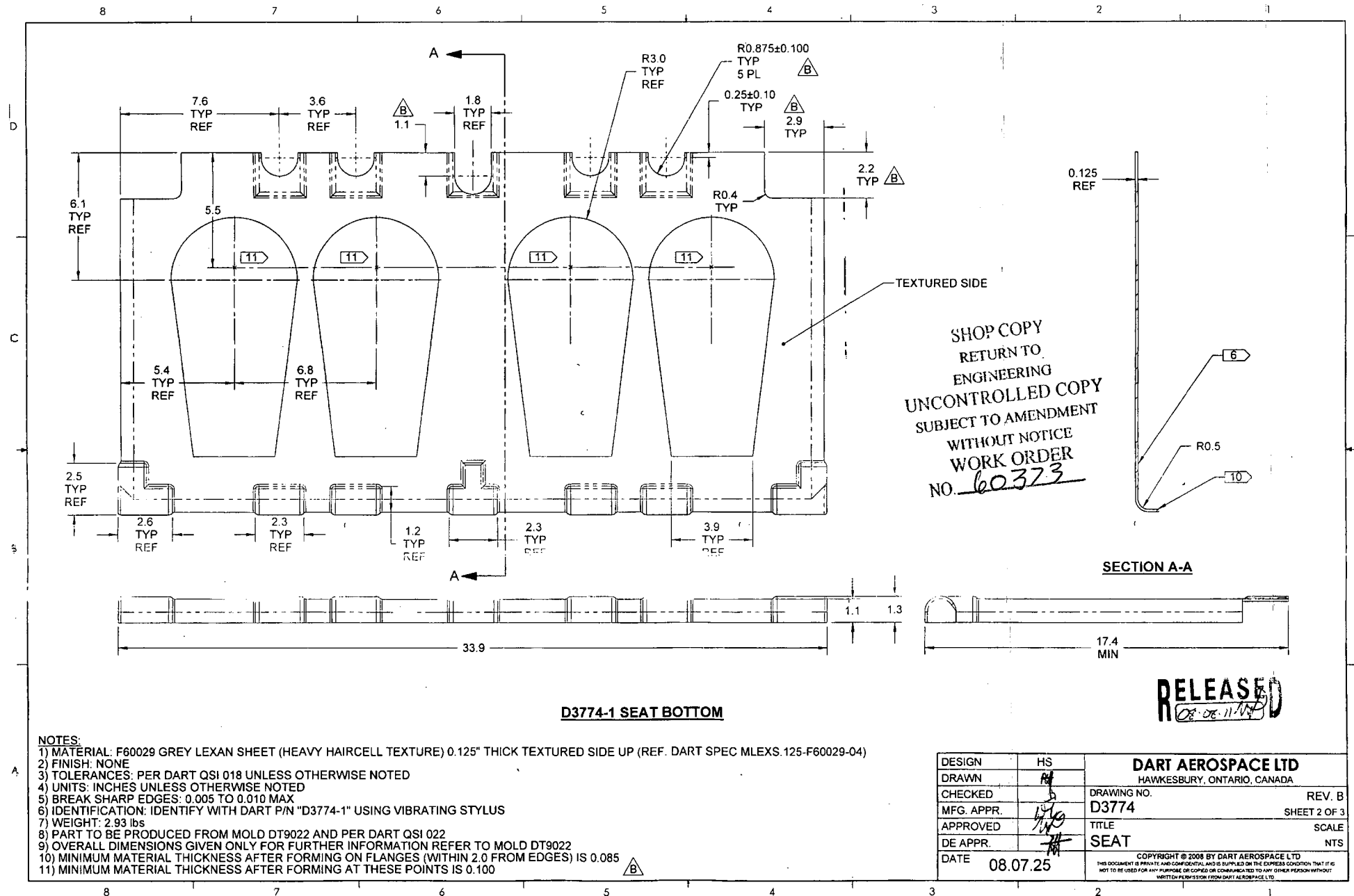


D3774-3 SEAT BACK

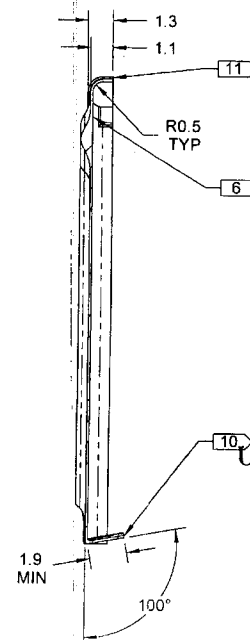
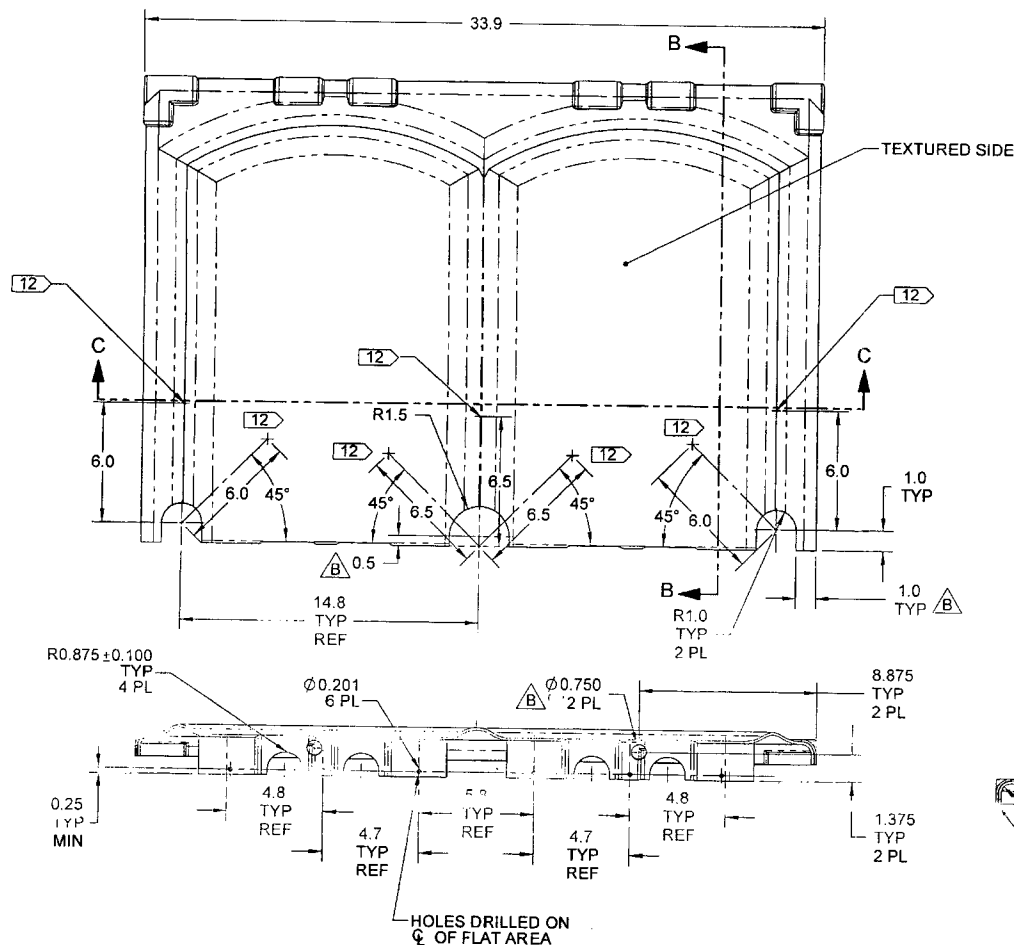
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60373
C210/716

RELEASED
06-08-11/12

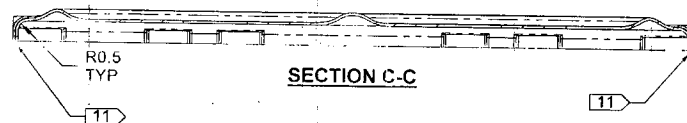
B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B5-3) REASON: MANUFACTURING CAPABILITIES		PH	08.07.25
A	NEW ISSUE		HS	08.06.23
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3774 TITLE SEAT		
DRAWN	PH			
CHECKED	PH			
MFG. APPR.	PH			
APPROVED	PH	REV. B		
DE APPR.	PH	SHEET 1 OF 3		
DATE	08.07.25	SCALE NTS		
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8 7 6 5 4 3 2 1



SECTION B-B



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60373

D3774-3 SEAT BACK

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
- 7) WEIGHT: 4.82 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
- 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
- 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

RELEASED
08-07-25

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RA		
CHECKED	5	DRAWING NO. D3774	REV. B
MFG. APPR.	W	SHEET 3 OF 3	
APPROVED	W	TITLE SEAT	SCALE NTS
DE APPR.	W	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.07.25		